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D350-636-017
Job Sheet 192986



Part No: D350-636-017

Job Qty: 1 pcs

Part Name: Skidtube LH, Run-on Landing, DART (Apical) Tri-Bag/Air Cruisers Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/5/19

Job Tracking No: return to stk (eng test)

Due Date: 4/10/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG d4168-043 rev.c IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP Rev:D 11.04.16 AS PER ECN 12-542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:F 18.11.12 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	4/10/19		0.00	4.65	Skidtubes - 1		DAS 28 9-89
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
250	Packaging 1-1 - Pick Kit - B4B	1 pcs	4/10/19		0.00	0.00	Packaging 1 - 1 - B4B		DAS 28 9-89
							Packaging 1 - 2 - B4B		
							Packaging 1 - 3 - B4B		
							Packaging 1 - 4 - B4B		
							Packaging 1 - 5 - B4B		
							Packaging 1 - 6 - B4B		
							Packaging 1 - 7 - B4B		
							Packaging 1 - 8 - B4B		
							Packaging 1 - 9 - B4B		
							Packaging 1 - 10 - B4B		
							Packaging 1 - 11 - B4B		
							Packaging 1 - 12 - B4B		
							Packaging 1 - 13 - B4B		
							Packaging 1 - 14 - B4B		
							Packaging 1 - 15 - B4B		
							Packaging 1 - 16 - B4B		
							Packaging 1 - 17 - B4B		
							Packaging 1 - 18 - B4B		
							Packaging 1 - 19 - B4B		
							Packaging 1 - 20 - B4B		
							Packaging 1 - 21 - B4B		
							Packaging 1 - 22 - B4B		



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Container No: S170715



Part: D350-636-017

Job No: 192986

Serial No/Batch: S170715

Revision: C

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17, T6 STC SH99 -

					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36	
260	QC 4	1 pcs	4/10/19	0.00 0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
265	DC - 1 - B4B	1 pcs	4/10/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
270	Packaging 3-1 - Stock - B4B	1 pcs	4/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
280	QC 21 - FG	1 pcs	4/10/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	

DAS
46
9-89

APR 1 1 2019

DAS
46
9-89

APR 1 1 2019

Part Op 110 - 1- Pick D2600-3 Bent 2- Debur FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D4168-3 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
 then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER
 POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes using drill Jig
 DT8150 & DT8864A for first side only DT8864B for second side. 4- Locate DT8330 off of blade fitting bolt holes and drill
 pilot holes for blade fitting 6-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.
 7-Open up holes of Detail S to 0.297" (total of 2 holes per side) +.201"(total of 1 per side DT9616) 8-Weld D2744 Cap as
 per Dwg D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch:
 9-Grind welds flush as per Dwg D4168

250 - Pick Kit

260 - QC4- 100% Inspect kits for completeness *****ensure antiseize is on AN8C21A bolts*****

265 - Document Control Photocopy blue file and type labels per PPP D350-636-017 CHG 006

270 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPPD350-636-017 Location :
 FG071

280 - QC21- Final Inspection - Work Order Release

009161

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-636-017	Skidtube LH, Run-on Landing, DART (Apical) Tri-Bag/Air Cruisers Float Comp.	1 pcs (1 ea)	110-Skidtubes - 1	5158255
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5156680
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5144726
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5125813
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5152948
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5133789

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D350-636-017	1	1	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	91	0
	D2741	1	67	0
	D3493-1	2	17	0
	MS21083C8	2	340	0
	NAS1149D0863J	2	591	0

Part Specifications

Specifications could not be found.

Change Record

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Part Number: D350-636-017/-018

Description: SKIDTUBE STD LH/RH w/ TRAINING WEARPLATE

[illegible]